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**AUTOMOTIVE HEADLINER HAVING IMPACT COUNTERMEASURES AND METHOD FOR MAKING THE SAME****Abstract of the Disclosure**

An automotive headliner including a substrate having upper and lower surfaces and a pair of opposite side edges with foam impact countermeasures integrally molded to the upper surface. The countermeasures form a pair of rails positioned adjacent the side edges and are adapted to absorb an impact from a vehicle occupant. A method of making the headliner includes inserting the headliner into a mold having first and second mold plates and corresponding first and second molding surfaces so that the lower surface faces the first molding surface. A release film is inserted into the mold between the upper surface and the second molding surface. The mold is closed and foam is injected into the mold between the upper surface and the release film. The mold is then opened and the headliner removed. The headliner may be removed prior to the foam being substantially completely cured.